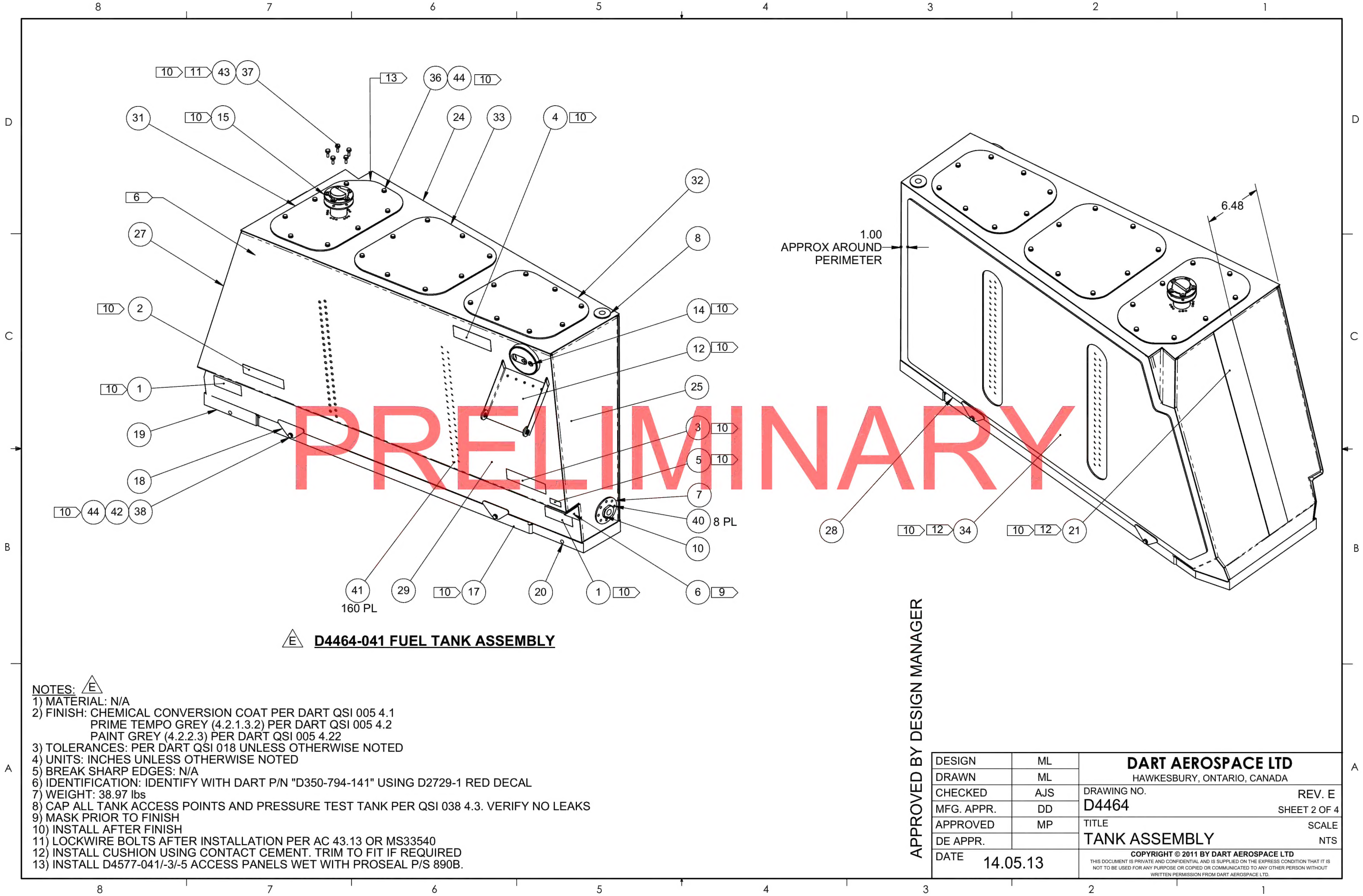


[illegible]



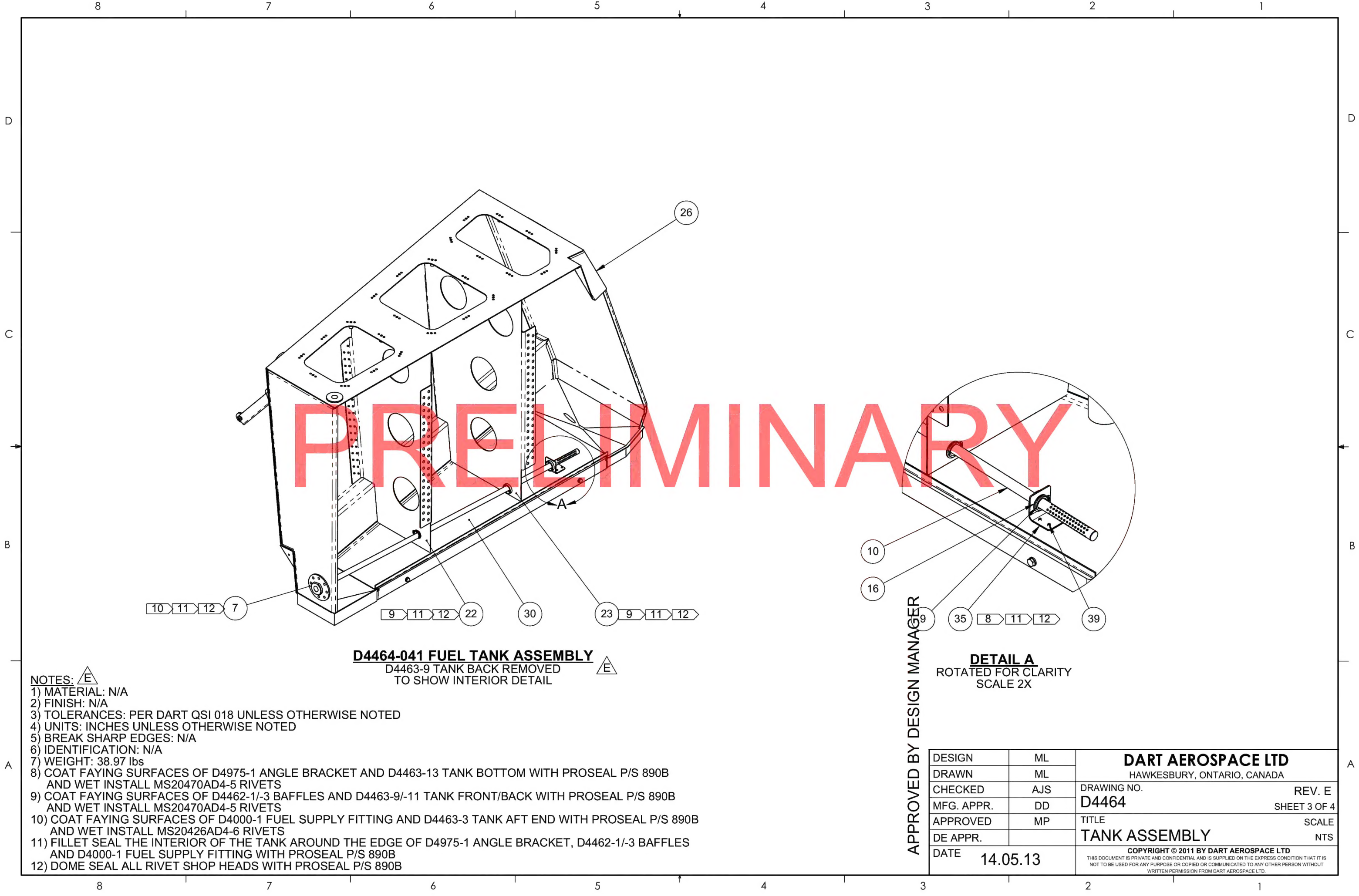
**D4464-041 FUEL TANK ASSEMBLY**

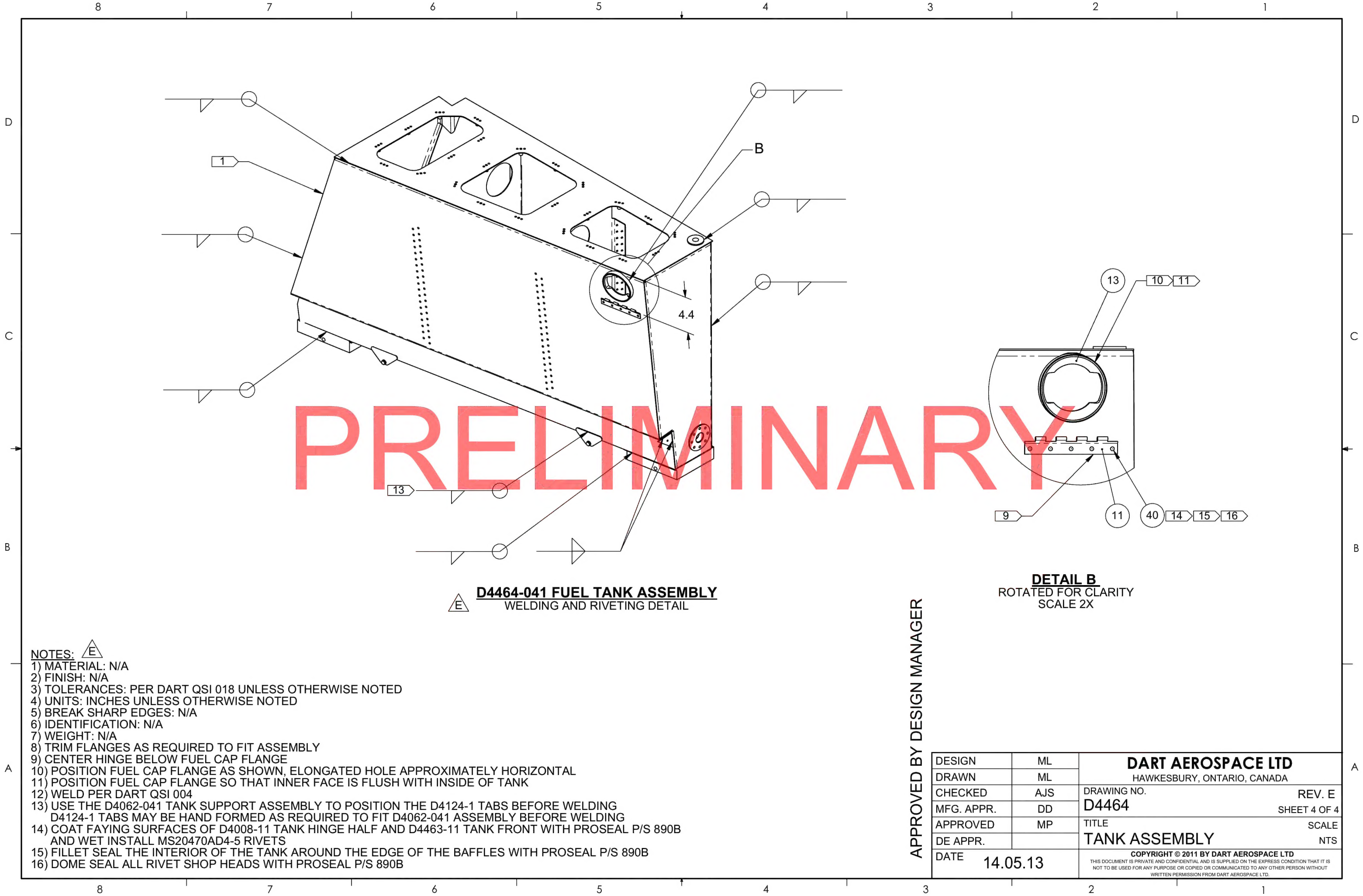
- NOTES: **E**
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2  
PAINT GREY (4.2.2.3) PER DART QSI 005 4.22
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-141" USING D2729-1 RED DECAL
  - 7) WEIGHT: 38.97 lbs
  - 8) CAP ALL TANK ACCESS POINTS AND PRESSURE TEST TANK PER QSI 038 4.3. VERIFY NO LEAKS
  - 9) MASK PRIOR TO FINISH
  - 10) INSTALL AFTER FINISH
  - 11) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
  - 12) INSTALL CUSHION USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED
  - 13) INSTALL D4577-041/-3/-5 ACCESS PANELS WET WITH PROSEAL P/S 890B.

APPROVED BY DESIGN MANAGER

DESIGN	ML	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO. <b>D4464</b>	REV. E SHEET 2 OF 4
MFG. APPR.	DD	TITLE <b>TANK ASSEMBLY</b> SCALE NTS	
APPROVED	MP		
DE APPR.			
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PRELIMINARY

**D4464-041 FUEL TANK ASSEMBLY**  
WELDING AND RIVETING DETAIL

**DETAIL B**  
ROTATED FOR CLARITY  
SCALE 2X

- NOTES:** 
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: N/A
  - 8) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
  - 9) CENTER HINGE BELOW FUEL CAP FLANGE
  - 10) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
  - 11) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK
  - 12) WELD PER DART QSI 004
  - 13) USE THE D4062-041 TANK SUPPORT ASSEMBLY TO POSITION THE D4124-1 TABS BEFORE WELDING  
D4124-1 TABS MAY BE HAND FORMED AS REQUIRED TO FIT D4062-041 ASSEMBLY BEFORE WELDING
  - 14) COAT FAYING SURFACES OF D4008-11 TANK HINGE HALF AND D4463-11 TANK FRONT WITH PROSEAL P/S 890B  
AND WET INSTALL MS20470AD4-5 RIVETS
  - 15) FILLET SEAL THE INTERIOR OF THE TANK AROUND THE EDGE OF THE BAFFLES WITH PROSEAL P/S 890B
  - 16) DOME SEAL ALL RIVET SHOP HEADS WITH PROSEAL P/S 890B

APPROVED BY DESIGN MANAGER

DESIGN	ML	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO. <b>D4464</b>	REV. E SHEET 4 OF 4
MFG. APPR.	DD	TITLE <b>TANK ASSEMBLY</b>	SCALE NTS
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